

Work Order ID 133875

Tuesday, June 23, 2015 8:02:52 AM

133875

Page 1

Item ID: D2596 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web, 205 Skidtube
 Start Date: 6/23/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/23/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: WLS Date: 15-06-23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2596	Rev D

100	Skidtubes	0.00							
100	Memo	0.00							
Skidtubes	1- Cut D2500-3-100 to length: 99.5"								
Skidtubes	2- Use Jig DT8093 to drill pilot holes #30								
	3- Open to 0.630" diameter as per Dwg D2596								
	4- Deburr								
110	Chemical Conversion Coat per QSI005 4.1	0.00							
110	Memo	0.00							
HandFinish									
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
120	Memo	0.00							
QC									
Quality Control									

15-7-2 JH/DGL

4 15-7-2 JH

(4) 15-07-02

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 Item Name: Web, 205 Skidtube
 Start Date: 6/23/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/23/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: JUN 23 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>46</u>	0.00				<u>4</u>	<u>0</u>	<u>15-7-2</u>	<u>DGC</u>
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

JUL 03 2015

JUL 03 2015

Picklist Print

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Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 6/23/2015

Required Date: 6/23/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	6.0000	1	4			

D2500-3-100

Ext'n -I' Beam Web 4"

Location

Loc Qty

Loc Code

HALL

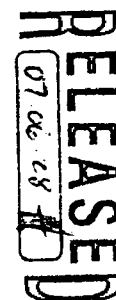
6

110687

6

(4)

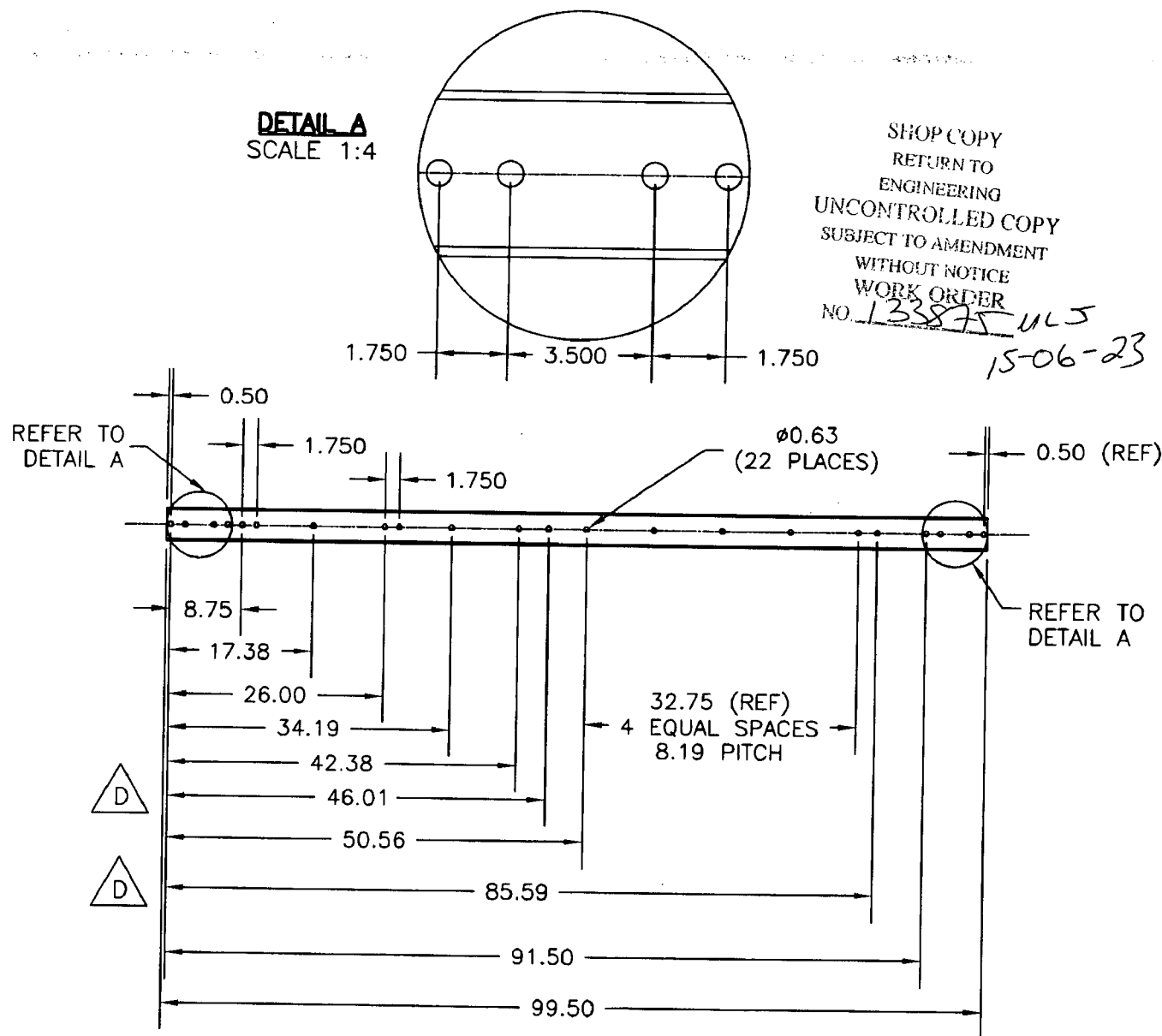
Doc 157-2.



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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 133875 111

NO. 133875 ULS
15-06-25

DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DESIGN		DRAWING BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO.		REV. D	
DATE		TITLE		SHEET 1 OF 1	
07.04.17		205 WEB		SCALE 1:20	
A	96.09.16	NEW ISSUE			
B	97.07.23	ø0.63 HOLE WAS ø0.56			
C	98.09.14	INCORPORATED DEO 9097			
D	07.04.17	INCORPORATED DEO 9183			

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